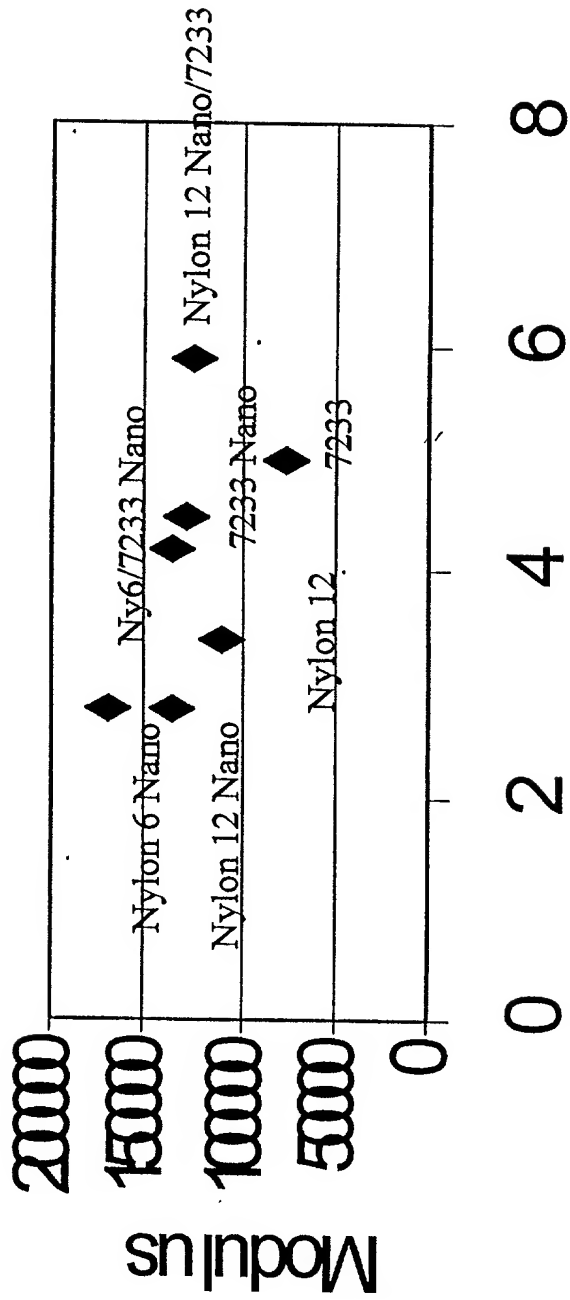


Modulus vs Toughness



Toughness

Figure 1

Nylon Nanocomposite Versus Standard Nylon Tubing

	Effect of Nanoparticles
Mechanical Properties	
Durometer (Modulus)	++
Burst Pressure	+
Tensile Strength	+
Tensile Elongation	-
Tear Strength	+
Heat Resistance (HDT)	++
Dimensional Stability	++
Surface Properties	
Dirt Retention	+
Printability	+
Lubricity	+
Barrier Properties	
Gas Barrier	++
Solvent Resistance	+
Aroma Barrier	+
UV Barrier	+
++ Much Improved	-- Not Improved
	+ Slightly Improved

Figure 2

Nylon 12, Nylon 12 Nano, Pebax 7233, and Pebax 7233 Nano

Property	ASTM Test Method	Nylon 12 Aesno TL	Nylon 12 Nano 5% I42	Pebax 7233 Nano 5% I42
Tensile Modulus	D638 (psi) Young	260,000	312,000	208,000
Tensile Str. @ Break	D638 (psi)	6800	6800	5400
Elongation @ Break	D638 (%)	256	329	464
Hardness Shore D	D2240	D74	D78	D72
Melting Pt.	D3418 (deg C)	179	178	172
Specific Grav.	D792 (g/cc)	1.02	1.04	1.03

*Increase of Stiffness and Ductility on Injection Molded Tensile Bars

*I42 is the nanoparticle from Nanocor fully designated I.42.TC

Figure 3

Nylon 12, Nylon 12 Nano, Pebax 7233, and Pebax 7233 Nano 6F Catheter Tubing

Property	ASTM Test Method	Nylon 12 Aesno TL	Nylon 12 Nano 5% I42	Pebax 7233 Nano 5% I42	Pebax 7233 Nano 5% I42
Tensile Modulus	D638 (psi) Young	110,000	136,000	75,000	127,000
Tensile Str. @ Max. load	D638 (psi)	8600	5500	11,000	9000
Elongation @ Break	D638 (%)	396	500	456	502
Tens strength x Elong @ break	(x 1,000,000)	3.4	2.8	5.0	4.5
Melting Pt.	D3418 (deg C)	179	178	172	172
Specific Grav.	D792 (g/cc)	1.02	1.04	1.02	1.03
Dimensional Stability		--	++	--	++
Dirt Retention		--	+	--	+

***Increased Stiffness and Ductility Plus With Dimensional Stability and Improved Surface**

*** Control of modulus from 75,000 to 136,000 all at similar melting points**

Figure 4

Nylon 11, Nylon 11 Nano, Pebax 2533, and Pebax 2533 Nano 6F Catheter Tubing

Property	ASTM Test Method	Nylon 11 Besno TL	Nylon 11 Nano 5% I42	Pebax 2533	Pebax 2533 Nano 5% I42
Tensile Modulus	D638 (psi) Young	112,000	134,000	<5000	<5000
Tensile Str. @ Max. load	D638 (psi)	12,600	7400	--	--
Elongation @ Break	D638 (%)	462	462	>500	>500
Tens strength x Elong @ break	(x 1,000,000)	5.8	3.4	-	-
Melting Pt.	D3418 (deg C)	190	190	--	--
Specific Grav.	D792 (g/cc)	1.03	1.05	1.01	1.02
Dimensional Stability		--	++	--	+
Dirt Retention		--	++	--	+

Figure 5

Nylon 12 Nano, Pebax 7233, Nylon 12 Nano/7233, and Pebax 7233 Nano 6F Catheter Tubing

Property	ASTM Test Method	Nylon 12 Nano 5% I42	Pebax 7233	Nylon 12 Nano/ Pebax 7233	Pebax 7233 Nano 5% I42
Tensile Modulus	D638 (psi) Young	136,000	75,000	124,000	127,000
Tensile Str. @ Max. load	D638 (psi)	5600	11,000	12,000	9000
Elongation @ Break	D638 (%)	500	456	494	502
Tens strength x Elong @ break	(x1,000,000)	2.8	5.0	5.9	4.5
Melting Pt.	D3418 (deg C)	178	172	--	172
Specific Grav.	D792 (g/cc)	1.04	1.02	1.03	1.03
Dimensional Stability		++	--	++	++
Dirt Retention		++	--	++	++

*Nylon 12 Nano/Pebax 7233 is a 50/50 blend with total nanoparticles concentration of 2.5%

Figure 6

Nylon 12 Nano, Nylon 11 Nano, Nylon 12 Nano/7233, and Nylon 11 Nano/7233 6F Catheter Tubing

Property	ASTM Test Method	Nylon 12 Nano 5% I42	Nylon 11 Nano 5% I42	Nylon 12 Nano/ Pebax 7233	Nylon 11 Nano/ Pebax 7233
Tensile Modulus	D638 (psi) Young	136,000	134,000	124,000	113,000
Tensile Str. @ Max. load	D638 (psi)	5600	7400	12,000	5100
Elongation @ Break	D638 (%)	500	462	494	251
Tens strength x Elong @ break	(x1,000,000)	2.8	3.4	5.9	1.3
Melting Pt.	D3418 (deg C)	178	190	--	--
Specific Grav.	D792 (g/cc)	1.04	1.05	1.03	1.04
Dimensional Stability		++	++	++	++
Dirt Retention		++	++	++	++

***The 50/50 blend of Nylon 12 Nano/Pebax 7233 was superior to the corresponding 50/50 blend of Nylon 11 Nano/Pebax 7233**

Figure 7

Nylon 12 Nano, Nylon 6 Nano, Nylon 6 Nano/7233, and Nylon 6 Nano/2533 - 6F Catheter Tubing

Property	ASTM Test Method	Nylon 12		Nylon 6		Nylon 6 Nano/Nylon 6 Nano		*Nylon 6 Nano/	
		Nano 5% I42 Nano XA2908		I42 Nano XA2908		Pebax 7233 /Pebax 2533		Pebax 7233 Nano	

Tensile Modulus D638 (psi) Young 136,000 171,000 136,000 94,000 356,000

Tensile Str. @ Max. load D638 (psi) 5600 9900 10,000 10,000 13,000

Elongation @ Break D638 (%) 500 287 415 600 338

Tens strength x Elong @ break (x1,000,000) 2.8 2.8 4.2 6.0 4.4

Melting Pt. D3418 (deg C) 178 217, 274 -- -- --

Specific Grav. D792 (g/cc) 1.04 1.12 1.06 1.06 1.07

Dimensional Stability ++ -- -- -- --

Dirt Retention ++ + ++
 Nylon 6 Nano XA2908 was obtained from Honeywell International at a reported nanoparticle level of 2.0%. The addition of Pebax to XA2908 improved processability and ductility.
 *for tubing 0.022" to 0.017 "

Figure 8